

**Amendments to the Claims:**

The following listing of claims will replace all prior versions, and listings, of claims in the application:

1-3. (Canceled)

4. (Currently Amended) A lithium ion secondary battery, comprising:

a can having a space defined therein while being opened at an upper portion thereof, and a flange extended outwardly from an upper end of the can, the can having a two-stage step formed on one side wall thereof, in such a manner that the can has a first lower surface, a first side wall extended upwardly from the first lower surface, a second lower surface located higher than the first lower surface while being extended outwardly from the first side wall, and a second side wall extended upwardly from the second lower ~~end~~surface;

a cap having a contact surface facing the flange of the can and the cap is not inserted into the can;

an electrode assembly located on the first lower surface and including a cathode plate and an anode plate; and

a protruded terminal connected to one of the cathode plate and the anode plate, ~~while being protruded to the outside~~and protruding through the second lower surface to an outside of the can,

wherein an outer surface of the flange of the can is micro-arc welded at an outer surface of the flange to an outer surface of the can~~the cap by means of micro-arc welding,~~ thereby forming a sealed container and the protruded terminal is located as close as possible ~~to the first side wall~~at the second lower surface of the can where the two-stage step is ~~formed~~formed so that a cooling jig can be installed and contacted to the sealed container such that only the outer surface of the flange of the can and the outer surface of the cap are exposed to the outside.

5-10. (Canceled)

11. (Previously Presented) The battery as set forth in claim 4, wherein the cap has a flat shape.

12-13. (Canceled)

14. (Previously Presented) The battery as set forth in claim 4, wherein the cap has a flange facing the flange of the can, and a space formed therein while being opened at a lower portion of the space.

15. (Canceled)

16. (Previously Presented) The battery as set forth in claim 4, wherein the flange has a width of 0.3 mm or more and 5 % or less of a long side length of the battery.

17. (Canceled)

18. (Previously Presented) The battery as set forth in claim 4, wherein the micro-arc welding is micro-plasma welding.